

Date: Monday, 6/12/2006 3:37:02 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: PROP ARM ASSEMBLY
Job Number	: 27507		
Estimate Number	: 10730		
P.O. Number	: NIA	Part Number	: D2982041
This Issue	: 6/12/2006 S.O. No. : NIA	Drawing Number	: D2982 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: NIA Type : PURCHASED PARTS	Drawing Revision	: B
Previous Run	: 25476	Material	: NIA
Written By	: <i>SEE COMMENT BELOW</i>	Due Date	: 7/16/2006
Checked & Approved By	: <i>06 06 13</i>	Qty:	13
Comment	: EST rev A 00.06.05 New Issue EC	Um:	Each
	: EST rev B 06.05.05 ECN 797 EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D2012107	Clevis
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 15.0000 Each(s)

Clevis

Pick:

Qty	Part number	Description	Batch
1	D2012-107	Clevis	B25483

2.0	D2022101	Spacer
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 30.0000 Each(s)

Spacer

Pick:

Qty	Part number	Description	Batch
2	D2022-101	Spacer	B25825

3.0	D2429041	Spring Clip Ass'y
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 15.0000 Each(s)

Spring Clip Ass'y

Pick:

Qty	Part number	Description	Batch
1	D2429-041	Spring clip ass'y	B25484 α 13

4.0	D2588	Bracket
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 30.0000 Each(s)

Bracket

Pick:

Qty	Part number	Description	Batch
2	D2588	Mounting channel	B24637

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Monday, 6/12/2006 3:37:02 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PROP ARM ASSEMBLY

Job Number: 27507

Part Number: D2982041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D2730

Door Prop



Comment: Qty.: 1.0000 Each(s)/Unit Total : 15.0000 Each(s)

Door Prop

Pick:

Qty Part number

Description

Batch

1

D2730

Prop arm

B24638

12 303.24

6.0

AN410A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 15.0000 Each(s)

Bolt

Pick:

Qty

Part number

Description

Batch

1

AN4-10A

Bolt

B17073

7.0

AN44A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 15.0000 Each(s)

Bolt

Pick:

Qty

Part number

Description

Batch

1

AN4-4A

Bolt

1719471

2.70

8.0

AN960JD416

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 30.0000 Each(s)

Washer

Pick:

Qty

Part number

Description

Batch

2

AN960JD416

Washer

17101369

9.0

MS20470AD45

Rivet, Universal Head



Comment: Qty.: 2.0000 Each(s)/Unit Total : 30.0000 Each(s)

Rivet, Universal Head

Pick:

Qty

Part number

Description

Batch

2

MS20470AD45

Rivet

17101369 M18461

PTD

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector
060704	9	Change to - 5					

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: Date: 06/07/11

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Monday, 6/12/2006 3:37:02 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PROP ARM ASSEMBLY

Job Number: 27507

Part Number: D2982041

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

MS21042L4

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 30.0000 Each(s)

Nut

Pick:

Qty

Part number

Description

Batch

2

MS21042L4

Nut

1719085

FF 06-07-04 13

11.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per dwg D2982

FF 06-07-04 13

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06-07-10 13

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

57114

06/07/10 13

14.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/07/11 13

Job Completion



06.07.11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART

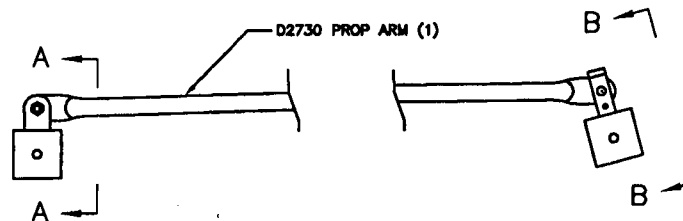
DESIGN RF	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2982	REV. B SHEET 1 OF 1
DATE 06.04.06	TITLE PROP ARM ASSEMBLY	SCALE NTS	
A	00.06.05	NEW ISSUE	
B	06.04.06	MS20470AD4-5 WAS MS20470AD4-6	

RELEASED

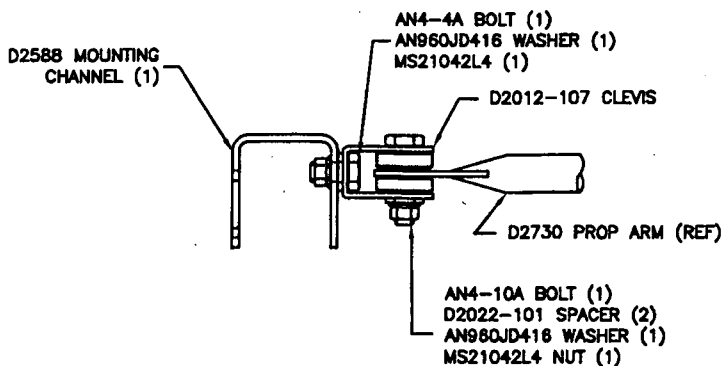
06-04-11 *[Signature]*

Qty -041	Part Number	Description
X	D2982-041	PROP ARM ASSEMBLY
1	D2012-107	CLEVIS
2	D2022-101	SPACER
1	D2429-041	SPRING CLIP ASSEMBLY
2	D2588	MOUNTING CHANNEL
1	D2730	PROP ARM
1	AN4-10A	BOLT
1	AN4-4A	BOLT
2	AN960JD416	WASHER
2	MS20470AD4-5	RIVET
2	MS21042L4	NUT (OR MS21042-4)

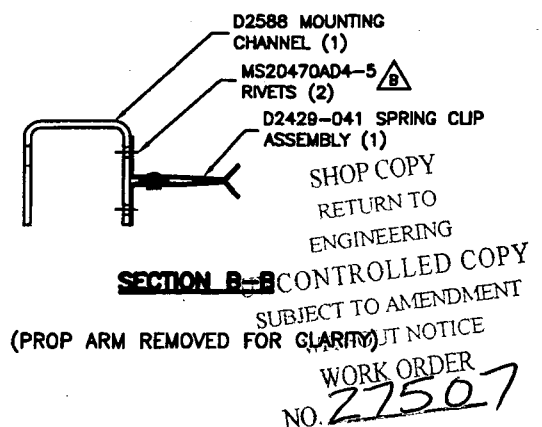
B



D2982-041 PROP ARM ASSEMBLY



SECTION A-A



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